

Work Order ID 164617

Tuesday, July 25, 2017 7:54:15 AM

164617

Page 1

Item ID: D4150-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Plate

Start Date: 8/3/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: JUL 25 2017 Date: DAS 21 Tooling: _____ Date: _____
QC: _____ Date: 9-89 SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4150	B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4150

Prog Rev: BDwg Rev: B

Deburr as required

0.32

(6)

07/27/2017

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.06

(6)

07/27/2017

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Item ID: D4150-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm Plate
Start Date: 8/3/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				<u>6</u>			DAS 38 9-89 JUL 26 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>51087</u> Memo	0.00 0.06				<u>6</u>			DAS 6 9-89 JUL 27 2017
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60							17/7/28 <u>48</u> DAS 21 9-89 JUL 27 2017

Picklist Print

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Work Order ID: 164617

164617

Parent Item: D4150-3

D4150-3

Parent Item Name: Arm Plate

Start Date: 8/3/2017

Required Date: 8/4/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	35.3200	0.0254	0.160421			

M304S11GA

304/316 0.125 Sheet

**

02/17/07/26

Location

Loc Qty

Loc Code

MAT020

35.32

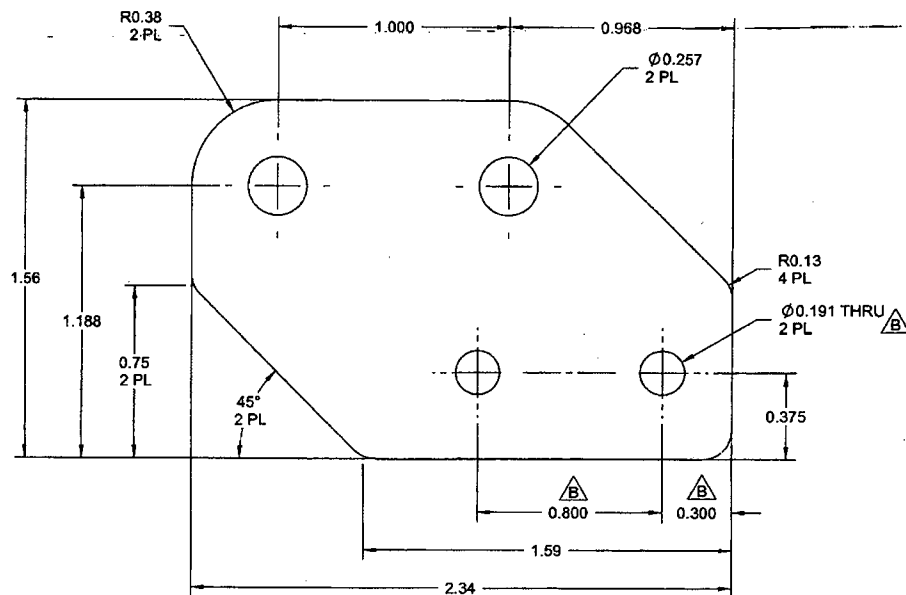
M137116

3.32

M137599

32

02



D4150-3 ARM PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *164617 MJS*
1707-25

RELEASED
2010-07-16
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. D4150	REV. B
CHECKED	<i>[Signature]</i>		SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE ATTACHMENT ARM ASSY	SCALE NTS
APPROVED	<i>[Signature]</i>	DATE 10.07.08	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	